



# YR-259 Axial Reeling Tape

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## Product Data Sheet

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Updated : March 1996  
Supersedes : January 1995

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**Product Description** A flatback tape specifically designed for bandoliering and sequencing of axial lead electronic components.

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**Physical Properties**  
Not for specification purposes

<b>Adhesive Type</b>	Natural Rubber	<b>3M ref :</b>
<b>Backing</b>	Flatback Paper	
<b>Thickness</b> (ASTM D-3652)	0.063 mm	
<b>Tape Colour</b>	White & Blue	
<b>Shelf Life</b>	12 months from date of despatch by 3M when stored in the original carton at 21°C (70°F) & 50% Relative Humidity	

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**Performance Characteristics**  
Not for specification purposes

<b>Adhesion to Stainless Steel</b> ASTM D-3330	8.3 N/10mm	
<b>Tensile Strength</b> ASTM D-3759	96.4 N/10mm	
<b>Elongation at Break</b> ASTM D3759	3%	

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**Application Techniques**

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| <p>1. Bond strength is dependent upon the amount of adhesive-to-surface contact developed. Firm application pressure develops better adhesive contact &amp; thus improves bond strength.</p> <p>2. To obtain optimum adhesion, the bonding</p> | <p>surfaces must be clean dry and well unified. A typical surface cleaning solvent is isopropyl alcohol &amp; water. Use proper safety precautions for handling solvents.</p> <p>3. Ideal tape application temperature range is 21°C to 38°C (70°F to 100°F).</p> | <p>Initial tape application to surfaces at temperatures below 10°C (50°F) is not recommended because the adhesive becomes too firm to adhere readily. However once properly applied low temperature holding is generally satisfactory.</p> |
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**Additional Product Information**

Tension controls should be set at minimum levels to ensure smooth operation.

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YR-259 Axial Reeling Tape

Features	Advantages	Benefits
Close tolerance slit width.	Accurate tape to tape alignment.	Eliminates adhesive exposure.
	Meets 6mm and ¼ inch slit width requirements.	Excellent compatibility.
Special high tensile, flatback paper backing: blue and white.	High strength combined with mechanical flexibility.	Conforms well to leads of different diameters.
		Excellent variable center distance feed (VCD).
	Easy tear in cross direction.	Ease in splicing.
	Polarity colour-coding.	Easily identified polarity.
Long ageing, thermosetting aggressive adhesive.	Excellent adhesive to adhesive bond.	Excellent tape to tape storage life of reeled components.
	Holds component pitch accurately.	Excellent VCD insertion.
	Excellent adhesion to paper bond.	Reliable pitch control.
Easy unwind.	Low tension.	No Strand breakage.
		NO WASTE due to high tension.
		Excellent tracking and guiding for optimum strand alignment.
Red (end of roll) tape indicator.	Alerts operator of needed roll change.	Protection against roll run off.
Levelwinding Zero overlap.	Minimal tape deformation.	Reliable tracking and excellent pitch control.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



### Specialty Tapes & Adhesives

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